

# Work Order ID 79078

\*79078\*

January-19-12 1:40:32 PM

Page 1

Item ID: D3009-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Cup  
 Start Date: 19/01/2012 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 02/02/2012 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/19 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3009	Rev B

100	Hardinge CNC LATHE SMALL	0.00							
*100*									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-TURN AS PER FOLIO FA130 & DWG D3009 FOLIO REV: <u>3</u> DWG REV: <u>3</u>		JL	12-01-31				(H0)	
	2-DEBURR AS REQUIRED								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control			JL	12-01-31		40			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 79078

**\*79078\***

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Item ID: D3009-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cup

Start Date: 19/01/2012 Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*smk 12/01/31*

40

0

130

Identify as per dwg & Stock Location: W/A

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

0 12-1-31 (X40)

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/2/11 df

*R (12-01-31)  
40*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 79078

\*79078\*

Parent Item: D3009-3

\*D3009-3\*

Parent Item Name: Cup

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A 07.12.18new issue EC  
IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No			110	f	45.9170	0.0479	2.016842			

\*M304R1 000\*

304 round bar 1.00

\*\*

SL 12-01-31

Location

Loc Qty

Loc Code

MAT029

45.917

109508

8.05

113457

37.867

\* 2.1

W/O:		WORK ORDER CHANGES					
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

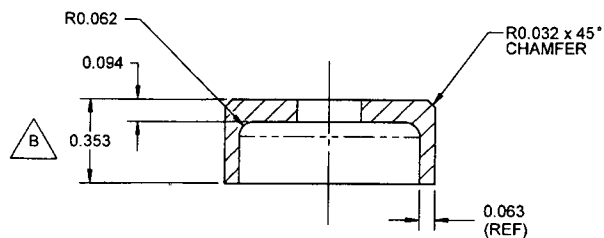
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

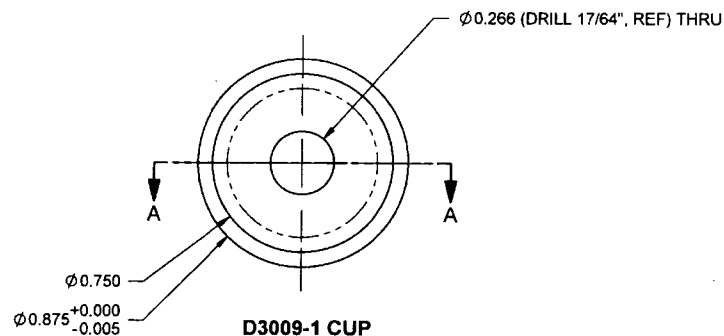
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





SECTION A-A



D3009-1 CUP



NOTES:

- 1) MATERIAL: AISI 1018-1025 ROUND BAR  
(REF DART SPEC M1018-R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

NO. 79.078 HLT  
12/01/19

RELEASED  
88.01.07

B	REDRAW/REFORMAT DWG. D3009-1 MAT'L WAS 1010-1025 NOW 1018-1025 (A8), 0.353 WAS 0.363 (D7), Ø0.266 WAS Ø0.257 (C5), ADD D3009-3 (SHEET 2)	CP	07.12.12
A	NEW ISSUE	RF	01.03.23
REV.	DESCRIPTION	BY	DATE
DESIGN	gpl	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	gpl		
CHECKED	gpl	DRAWING NO.	REV. B
MFG. APPR.	gpl	D3009	SHEET 1 OF 2
APPROVED	gpl	TITLE	SCALE
DE APPR.	gpl	CUP	2:1
DATE	07.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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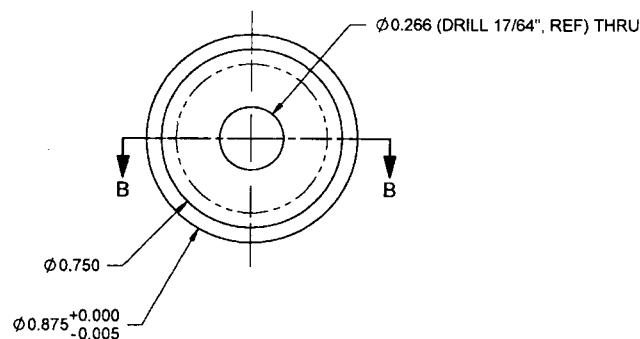
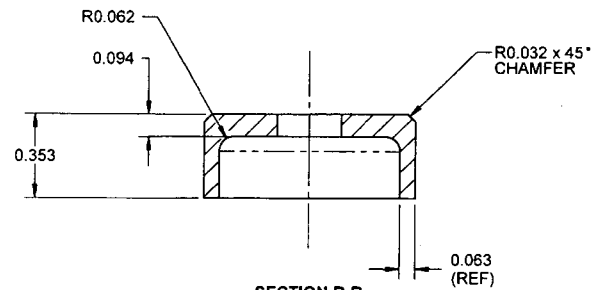
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

79078



**D3009-3 CUP**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR  
(REF DART SPEC M304R)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

**RELEASE**  
08-01-07-14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3009	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CUP	2:1
DATE	07.12.12	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
				134/3 - 3/11				

**NOTE:** Date & initial all entries